

SOUTH PRODUCTION NOTES

**November 13, 2013
Midnight Shift**

**BASF EMPLOYEES
136 Last Recordable
157 Last Lost Time**

#1 MED Cean for AL-4126: Continue running.

There is water and oil mixed in green gear box-work order is in.

#1 RC / AL-4126: Ready. Fire up after starting batches on MED. NOTE: When we start feeding the calciner the first material needs to be drummed off in 1-2 haz drums, then switch to bags per the MOD

Exhaust to Trimer

Midnight shift notes: We could not get the dryer lit. A work order was written.

Day: First batch did not go well. It will be extruded, dried, calcined and scrapped as flush.

Afternoon: Running good material after the scrap extruded and calcined. Continue.

#2 MED line/ Cu-0860 done, clean for Cu-0602: Complete. Started cleaning per clean-out sheet.

#2 RC/ Cu-0860 done, clean for Cu-0602: Bringing down, will need to reverse later on 11-7 shift Wednesday morning. Then keep down until Cu-0602 batches get going (late weekend or early next week).

NOTE: Copper Reclaim the supersack of wet mix batches.

Exhaust to F1

Midnight shift notes: 2nd wet mix batch was run slowly. On hold.

Day: Save remaining Cu 3818 for upcoming Cu-0602 trial. Finishing last batches

Afternoon: Batches complete, began cleaning on MED line. Calciner complete, bringing calciner down.

Tank 7 / AMT Solution / D-1795: Keep temperatures between 25 and 35 degrees C.

NOTE: The blank has been removed to pump directly from Tank 7 to old pfaudler weigh tank.

Midnight shift notes: Tank level at 10% as of 6am. May have enough for 1 batch.

Day: Tank of AMT made

Afternoon: Continue.

Old Pfaudler D-1795: Goal is to keep the entire pipeline full (totes, hopper, pfaudler, and make sure 7 tank has enough material or make another tank as needed). Continue to

write down “dryer feed times” on each batch of totes, and when possible direct feed off of the dryer into the calciner hopper. Only feed into the bag-off from the dryer when necessary.

#3 MED / D-1795 NAQ: Continue to write down “dryer feed times” on each batch of totes, and when possible direct feed off of the dryer into the calciner hopper. Only feed into the bag-off from the dryer if necessary. **DO NOT BUILD FEED!!! KEEP FEEDING THE CALCINER DIRECTLY INTO THE HOPPER. HAVE A BAG HANGING OVER THE HOPPER IN CASE WE ENCOUNTER A GAP IN THE PIPELINE...BUT ALWAYS FEED THE CALCINER.**

#3 RC / D-1795 NAQ: Continue feeding. Watch the feed rate on this calciner! Sample per the MOD. **DO NOT BUILD FEED!!! KEEP FEEDING THE CALCINER DIRECTLY INTO THE HOPPER. HAVE A BAG HANGING OVER THE HOPPER IN CASE WE ENCOUNTER A GAP IN THE PIPELINE...BUT ALWAYS FEED THE CALCINER.**

Exhaust to CTO

Midnight shift notes: Continued to run. 3 bags off on midnight shift.

Day: No issues.

Afternoon: Continue

#4 RC / clean for D-5202: Go ahead given to run #4 RC. Due to limitations on Abbe, the decision was made to run remaining clay to make more D-5202.

Exhaust to Trimer

Midnight shift notes: Calciner was walked over by floor CRT and started early on midnight shift.

Day: No issues

Afternoon: Calciner on hold...scale not working. Work notification written for OCS to correct scale, hopefully Wednesday.

National Dryer / D-5206 : Several Abbe batches made and all were very wet. Continuing to feed the last of the wet batches....not very fun.

Midnight shift notes: Remaining wet material was fed. 1 batch was made on midnight shift and can be fed on day shift.

Day: Can run last load of D-5206 from last night on afternoon, was not run on day

Afternoon: Abbe to run 11/7 shift tonight...issue with vacuum hose was corrected. The little bit of material from early Tuesday morning batch was fed through the National Dryer.

PK Blender / AL3917:

Maintenance to work end seals tomorrow. Will be down until then

Midnight shift notes: Ran pill mix 2nd half of midnight shift.

Day: End seals leaking too badly to continue to run.

Afternoon: No change...waiting for end seal repairs on Wednesday

#5 RC / 1506: Stage #1 flowmeter on Trimer repaired, feed restarted Monday early afternoon.

Be advised that we now have the ability to control the feedscrew (on / off) from the CRT room. Feed screw is set at 11Hz with no issues thus far.

Exhaust to Trimer

Midnight shift notes: #5 continues to run.

Day: No issues

Afternoon: No issues

New Pfaudler / Celanese Trial: Batches are only to be impregnated on 1st shift with Justin.

Midnight shift update: Batch was unloaded on midnight shift and is on the 2nd floor of building 31.

Day: 2nd Platinum impregnation completed today

Afternoon: Dropping Tuesday afternoon batch after 10:00 pm, take to #6 dryer. No new impregnation batch until Wednesday morning/afternoon.

#6 DRYER - RC / Celanese trial: Start running impregnated batch 11/12/13

Only use the square buggies that have been cleaned out and have the "CEHW" label on the side of the buggy.

Exhaust to Sly Scrubber

Midnight shift notes: Last tote fed. Need to get disposition on the 2 drums of material from the feed end of the calciner(from when the material was leaking out) and the 2 totes that are on the 2nd floor of building 31. Feed rate was around 200lbs. per hour.

Day: Will start to run 1st impregnated batch this afternoon. Drums are 150 lbs, will do about 1 drum every 30 mins.

Afternoon: Buggies should be full from late 3-11 shift, make sure dryer is fed and keep person on this consistently.

Tank 6 / tank rinsed out: Tank is empty. Pump was replaced on Thursday.

Tower 3 / E-406: Continue on. Due to be unloaded mid afternoon shift.

Midnight shift: No change.

Afternoon: Tower was unloaded but shaker (tower vibrator) was not working until maintenance worked on it late 3-11 shift. All material out of tower but still need to load. Need to coordinate with Tower operator as he will be in hydrogen phase on Tower 6 during 11-7 shift.

Tower 6 / Q-VAM next:

Midnight shift notes: Tower load was finished being loaded after the hoist chain was removed.

Day: No change.

Afternoon: Continue. QVAM should be coming down around 11:00 am-12:00 noon on Wednesday.

Harrop Kiln - AI-3921 T 3/16: Continue running. A work notification has been written to have maintenance take a look at the automatic pusher at the cool down zone in the Kiln. It appears as if the clutch is disengaging while pushing carts.

Work notification written for one of the blowers on the kiln (#5 blower stopped working). Still operable, but maintenance needs to see Tower operator for more information.

Make sure pills do not mound in the bag (spread them out and they will fill to the 1500 lb level).

Midnight shift notes: continued on.

Afternoon: Continue

North Screener / Cu-0860: Completed...hold.

South Screener / E-406: Continue E-406.

Midnight shift notes: Ran 1st half of midnight shift. 3 totes remaining.

Day: Ran 4 hours on day shift.

Afternoon: Ran 8 hours. Should be 7-8 totes (including what was unloaded today from the tower)

#2662 Pill Machine / AI-3917 3/16: Ran all day. Down now for protection fault.

#2664 Pill Machine / AI-3917 3/16: PM cleaning.

Midnight shift notes: 2662 shut down due the inability to control the speed. Machine was speeding up rapidly and could not be slowed down.

Day: 2662 repair in progress, issue with starter. 2664 continues

Afternoon: 2662 is running, 2664 down for cleaning.

HC-11 Tanks / Cleaning for 1520: Plan to start 1520 liquids later this week

Midnight shift notes: Tank 107 was sent to wastewater.

Day: Tanks inspected. Plan to start 1520 liquids later this week. Tank 4 needs more attention. Wash tonight and pump over to Tank 6. Then Tote off and send to waste water.

Afternoon: Tanks in good shape, still need to wash/rinse out 107.

Abbe Blender / D-5206: Shut down due to solution being present in the flex hose of the scrubber line. The abbe lid was opened and the screen reset, then lid resealed. Construction will be 1st AND 2nd shift this week. Only run Abbe on 3rd.

Midnight shift notes: 1 batch was made and then solution was noticed in the flex line of the scrubber.

Day: flex hose issue was resolved and hose resupported. Ready to run this evening.

Afternoon: Vacuum line on trunion wheel was corrected, continue batches on 11-7.

Tunnel Kiln #2 / Set up for Al-3921: Lot 4 bags 1 and 2 can be fed. Do not feed bags 3-8. We can resume with bag 9 after bag 2.

Midnight shift notes: Test car should be ready to unload around 9am.

Day: Waiting on Justin for instructions

Afternoon: Feeding lot 4, bag 1 per Justin's instructions Tuesday afternoon.

Priorities 1 through 11 are basically all the same priority, should be considered urgent and will require call outs for maint issues.

- 1) D-1795 NAQ - East Pfaudler/#3P&S Dryer/#3RC
- 2) Reduction Towers, specifically QVAM on Tower 6 and screening of E-406 TR
- 3) Cu-5020 P then 1520 Solution - HC-11 Tanks
- 4) 1506 then 1520 - PK/#5 RC/Trimer
- 5) D-5206 - Safety/Abbe/National Dryer/#4RC
- 6) Celanese Trial - West Pfaudler/HC-11 dryer & #6 RC
- 7) Al-3921 T 3/16 - Harrop Kiln
- 8) Al-3917 T 3/16 - Horne Tableting
- 9) Cu-0860 E 1/16 3F - #2 MED/#2 RC
- 10) Al-3917 Pill Mix - PK Blender, as needed to supply Al pill mix to the Hornes
- 11) Clean up and change over on #1MED/#1 RC